

Work Order ID 163003

163003

Page 1

Tuesday, June 20, 2017 1:29:02 PM

Item ID: D412-711-101

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Vertical Reference Window

Start Date: 6/20/2017 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 6/27/2017 Req'd Qty: 2.00 *2*

Customer:

Reference:

DAS
13
9-89

Approvals:

Process Plan:

Date: JUN 20 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D412-711-101

C

110

0.00

110

THERMOFORMING MACHINE

Purchasing

Memo

0.00

Purchasing

ISSUE P/O:

SUPPLIER: PLASTECH

MANUFACTURE D412-711-101 AS PER DWG

C OF C IS REQUIRED

2

JUN 20 2017

DAS
13
9-89

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

HAND FINISHING THERMOFORMING

Packaging

Memo

0.00

Packaging

DAS
6
9-89

AUG 14 2017

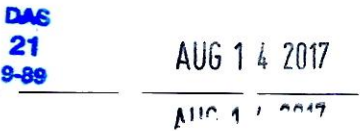
Work Order ID 163003***163003***

Page 2

Tuesday, June 20, 2017 1:29:02 PM

Item ID: D412-711-101 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Vertical Reference Window
Start Date: 6/20/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/27/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				<u>2</u>			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>1x sold 1x f8099</i>	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							



AUG 14 2017

Picklist Print

Tuesday, June 20, 2017 1:29:01 PM

Page 1

Work Order ID: 163003

163003

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 6/20/2017

Required Date: 6/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL
outside process DP Verify DD

IPP Rev. B.
IPP Rev.C 17.06.20 Now

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-101P *D412-711-101P* Replacement Bubble Window		Purchased	No				Each	0.0000	**	2	0-89 DAS	AUG 14 2017	

MACRLICS-236

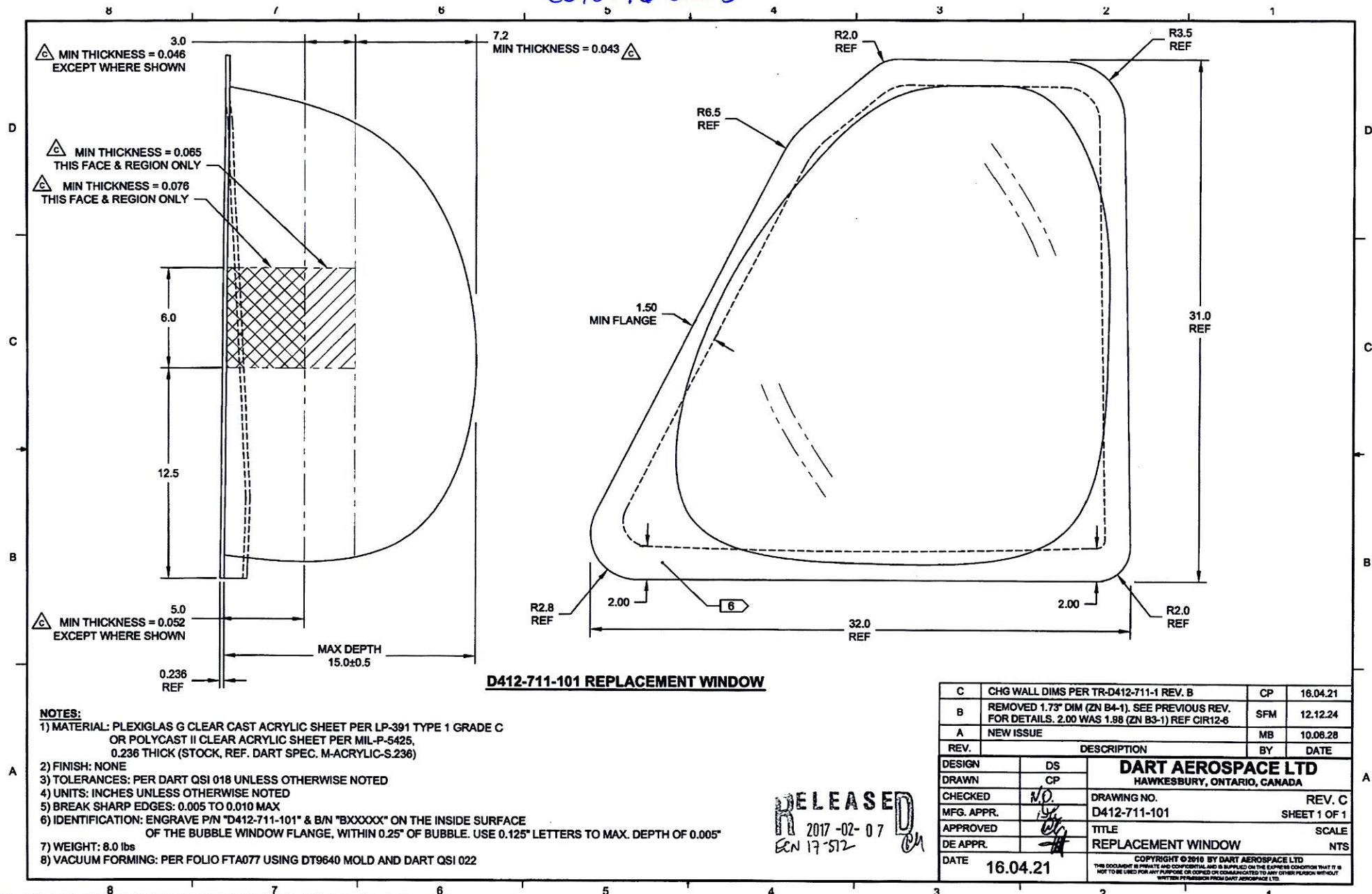
M 136776

42.666675F ~~42~~ AUG 14 2017

JUN 20 2017

DAS
13
9-89

W10:163003





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36772

Purchase Order Date 6/20/2017
PO Print Date 6/20/2017

Page Number 1 of 2

Order From :

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUN 21 2017

Contact Name

Vendor Phone

416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 60

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Exter F
1	D412-711-101P	Replacement Bubble Window	6/27/2017 Yes 6/27/2017		2.00 Each	\$225.75 JAB 38 1-89	\$45

MANUFACTURE AS PER DWG D412-711-101 REV. C
B163003

Line Total: \$4

2	D212-725-1-251	Forward Duct	6/27/2017 Yes 6/27/2017		1.00 Each	\$148.75	\$1
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MANUFACTURE AS PER DWG D4065 REV. C (D212-725-1-251/253)
B163005

8177-14

Line Total: \$

Note:

Reprint - Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 23803
Shipment Date: 08/11/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
Attn: ROBERT ABOUD
T
O

S DART AEROSPACE LTD.
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
Attn: ROBERT ABOUD
T
O

Purchase Order
PO36772
Carrier Account #

Sales Order
SO-019003

Incoterms

Payment Method
N/A
Tracking Number

Ship Via
PICK UP -

Item Number - Revision

Description

Quantity UOM
Shipped

CUSTOM -

CLEAR ACRYLIC PLEXIGLAS G REPLACEMENT
WINDOW
HS Code: 8708.8.1000 - Country of Origin : CA
PER DWG D412-711-101
CUSTOMER SUPPLIED MATERIAL

2 EA

AUG 14 2017

DAS
38
9-89

Number of Containers

Gross Weight

Shipped By

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM

P- 416 736 0004
F- 416 736 0010

Shipment Number: 23803
Shipment Date: 08/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE LTD.
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
PO36772
Carrier Account #

Sales Order
SO-019003

Ship Via
PICK UP -

Incoterms

Payment Method
N/A
Tracking Number

Item Number - Revision Description

CUSTOM -

CLEAR ACRYLIC PLEXIGLAS G REPLACEMENT

WINDOW

HS Code: 8708.8.1000 - Country of Origin : CA

PER DWG D412-711-101

CUSTOMER SUPPLIED MATERIAL

Quantity UOM
Shipped

2 EA

Number of Containers

Gross Weight

Shipped By

Non-Conformance Record



Customer: DART AEROSPACE

Sales Order # 50-019003-001

P.O. P036772

Item/Part # DART0118 Lot # 891754

Quantity: 1 SHEET

LOCATION OF NON-CONFORMANCE

☐ Bending

☒ Thermoforming

☐ CNC Laser

☐ Receiving

☐ Sanding

☐ Clean room

☐ CNC Router

☐ Shipping

☐ Fabrication

☐ Stock

☐ CNC 5 Axis

☐ Other _____

MATERIAL

Item # DART0118 Dimensions: .236 x 48 x 96 Yield / Sheet: 2

Description: CLEAR PLEXIGLAS GM

Amount Inspected: 2 Unit Of Measurement

Amount Rejected: 2 ☒ Parts ☐ Sheets ☐ Other _____

Location of Rejected Material: ☐ QA Area ☒ Other RE-CYCLE.

PROBLEM DESCRIPTION: MALFUNCTION OF THE SENSOR WHICH CONTROLS THE VACUUM DRAW ON THE FORMED BUBBLE WINDOW LEAD TO THESE TWO FAILURES.

SENSOR WAS REPAIRED/REPLACED AND PARTS WERE SUCCESSFULLY COMPLETED.

QA Suggested Action: ☐ Repair ☒ Scrap ☐ Use as offcut ☐ Other _____

Created by: AS Date: AUG 10/17 NCR # 061

DISPOSITION (For QA Use)

Action taken: _____

As Per: _____ Via: _____ Date: _____

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # P036772 SO # 019003-

Part #	D412-711-101	Qty.	2	Batch #	001
Description	REPLACEMENT BUBBLE WINDOW	Usage	1	Lot#	11634
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial
Part #		Qty.		Batch #	SO-line
Description		Usage		Lot#	Material Serial

Note: All parts are not identified as meeting QSI044.

By: A. Shelton Date: AUG 10/17 C OF C # 001
(Approved QA Signatory)

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

DART AEROSPACE LTD		Work Order:	P036772
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number:	D412-711-101
Inspection D-412-711-101 Rev: 2		#1	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	☒	☐		
Shape Definition	☒	☐		
Texture Retention	☒	☐		
Material imperfections such as bumps, cracks, voids, scratching	☒	☐		
	☐	☐		
	☐	☐		
	☐	☐		
	☐	☐		

Measured by: <u>D. Lopez</u>	Date: <u>17/08/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	+/- 0.50"	14.75"	☒	☐		
2.00"	MIN	2.16"	☒	☐		
1.5"	MIN	1.6"	☒	☐		
0.076" @ 5"	MIN	0.091"	☒	☐		
0.063" @ 8"	MIN	0.081"	☒	☐		
0.046" TOP	MIN	0.054"	☒	☐		
			☐	☐		
			☐	☐		
			☐	☐		
			☐	☐		
			☐	☐		
			☐	☐		

Measured by: <u>D. Lopez</u>	Date: <u>17/08/09</u>
Audited by: <u>38</u>	Date: <u>AUG 14 2017</u>
Preliminary Approval: <u>0.89</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order: P036772
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number: D412-711-101
Inspection D-412-711-101	Rev: C	#2 Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>D. Legen</u>	Date: <u>17/08/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14.8"	✓			
2.00"	MIN	2.1"	✓			
1.5"	MIN	1.6"	✓			
0.076" @ 5"	MIN	0.105"	✓			
0.063" @ 8"	MIN	0.092"	✓			
0.046" Top	MIN	0.057"	✓			

Measured by: <u>D. Legen</u>	Date: <u>17/08/09</u>
Audited by: <u>38</u>	Date: <u>AUG 14 2017</u>
Preliminary Approval: <u>980</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order: R036772
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number: 0412-711-101
Inspection D-412-711-101 Rev: C		#2 Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Leger

Date: 17/08/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	+/- 0.50"	14.75"	✓			
2.00"	MIN	2.08"	✓			
1.5"	MIN	1.59"	✓			
0.076"@5"	MIN	0.107"	✓			
0.065"@8"	MIN	0.083"	✓			
0.046" TOP	MIN	0.051"	✓			

Measured by: D. Leger

Date: 17/08/09

Audited by: DAS 38

Date: AUG 14 2017

Preliminary Approval: 9-89

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

DART AEROSPACE LTD		Work Order: P036772
Description: F 412 - REPLACEMENT BUBBLE WINDOW		Part Number: P412-711-101
Inspection D-412-711-101	Rev: C	#1 Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	☒	☐		
Shape Definition	☒	☐		
Texture Retention	☒	☐		
Material imperfections such as bumps, cracks, voids, scratching	☒	☐		

Measured by: D. Leger

Date: 17/08/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.0"	± 0.50"	14.75"	☒	☐		
2.00"	MIN	2.16"	☒	☐		
1.5"	MIN	1.6"	☒	☐		
0.076" @ 5"	MIN	0.091"	☒	☐		
0.065" @ 8"	MIN	0.081"	☒	☐		
0.046" TOP	MIN	0.054"	☒	☐		

Measured by: D. Leger

Date: 17/08/09

Audited by: 38

Date: AUG 14 2017

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	16.01.20	New Issue	KJ	

Work Order ID 163003

Tuesday, June 20, 2017 1:29:02 PM

163003

Page 1

Item ID: D412-711-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Vertical Reference Window

Stop

NS2

Start Date: 6/20/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/27/2017 Req'd Qty: 2.00

2

Customer:

Reference:

DAS

13

Approvals:

Process Plan:

9-89

Date: **JUN 20 2017**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	C								

110

0.00

110

THERMOFORMING MACHINE

Purchasing

Memo

0.00

Purchasing

ISSUE P/O:

36772

SUPPLIER:PLASTECB

MANUFACTURE D412-711-101 AS PER DWG

C OF C IS REQUIRED

2

JUN 20 2017

DAS

13

9-89

140

0.00

140

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Packaging

Memo

0.00

Packaging

AUG 14 2017